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RBT18604

Job Sheet 201770



Part No: RBT18604

Job Qty: 1 pcs 4

DAS
21
9-89

Part Name: Tail Rotor Swashplate Bearing ReGrease Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/19

Job Tracking No:

Due Date: 12/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18604 Rev.5 IPP Rev. A 18.10.10 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/4/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	12/4/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/4/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		

GP 19-11-14.

DAS:
40
9-89

NOV 1 1 2019

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAF
				Packaging 3 - 7 - B4B	20
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	12/4/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 110 - (Small Fab) 1-Assemble as per DWG.
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____) The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1095K41	Zerk 44	4 Ea (1 ea)	110-Small Fab - 1	5075943
2-230	O-Ring 78	4 Ea (1 ea)	110-Small Fab - 1	122105
RBT18604-1	Body 146	4 pcs (1 ea)	110-Small Fab - 1	776624
RBT18604-3	Plug 146	4 pcs (1 ea)	110-Small Fab - 1	230392

Job Allocations

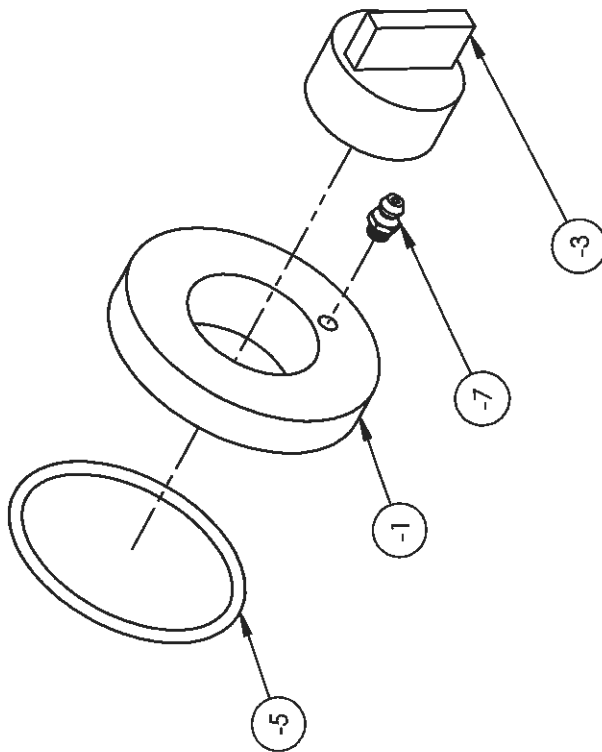
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	1095K41	1	4	0
	2-230	1	99	0
	RBT18604-1	1	1	0
	RBT18604-3	1	0	0

Part Specifications

Specifications could not be found.

Plex 10/10/19 11:15 AM Dart.lajeunesse.marie

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DISTANCE FROM FACE TO STEP INCREASED TO .30 TO ENSURE ADEQUATE THREAD ENGAGEMENT.	3/9/2001		
2		O-RING GROOVE ENLARGED TO BETTER FIT O-RING.	3/23/2001	DW	
3		DISTANCE FROM FACE TO STEP REDUCED TO .265.	4/4/2001		
4		GREASE FITTING CH'D TO 45° FOR EASE OF USE. MUST FACE OUT.	2/10/2003		
4A		CH'D TITLE BLOCK & REVISION BLOCK. CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL. -1 CH'D ENGRAVE NOTE, LABELED SECTION VIEW.	1/13/2010	RJC	
5	16-0202	-1 CH'D DIM WAS Ø3.00 CLEANUP IS Ø3.00 ±.002. WAS Ø.09 THRU 1.14. Ø.213 ∇ 1/4. 1/4-28 UNF FOR GREASE FITTING IS Ø.09 THRU 1.14. WAS BORE Ø1.505 ±.012/-0.000 & THREAD 1.563-18 UNJS -38 PER MIL 8879 IS 1.563-18 UNJS THRU 1.14. 1/4-28 THRU 1.14. -3 DELETED DIM. 63. ADDED DIM'S 1.38, .65, .13. CH'D MATERIAL WAS 316L ON 100% DELIN. IS WHITE DELIN (ACETAL -5 CH'D B/O INFO WAS PARKER #2-23015 0176 X C.S. #012-110. X 02.75 #2-2301 CHRISTOPHER SEALS). MAT'L IS BUNAN-N. -7 CH'D B/O INFO WAS MSC #068040725 OR EQUIVALENT IS MCMASTER-CARR #1095K41.	10/24/2016	RJC	JAG



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 201770
151

[illegible]



Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

DEPARTMENT/PROCESS

DISPOSITION

Job: _____	Skid-tube	Cross tube	Eng. (Non-AW)	Engineering
Part No. _____	Machining	Small Fab	Prod. Eng. Coord.	Water Jet
	Large Fab	Finishing	Rec/Store/Packaging	Supplier
				Quality

MRB (Q51042)

QTY Affected :

Sequence #:

Disposition

Description Work Order Deviation

Completed By

Lead hand / Supervisor

QC / QA Coordinator

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Root Cause

Operator
Manufacturing Process
Equip/Tooling
Handling/Preservation
Material
Product Improvement
Process Improvement
Human Factors

Other/Details: